












Date: Monday, 03/11/2008 1:30:32 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET RIB
Job Number	: 43165	Part Number	: D31661
Estimate Number	: 10402	Drawing Number	: D3166 REV A1
P.O. Number	:	Project Number	: N/A
This Issue	: 03/11/2008 S.O. No. :	Drawing Revision	: A1
Prsht Rev.	: NC	Material	:
First Issue	: // Type : LARGE FAB ASSY	Due Date	: 15/11/2008 Qty: 20 Um: Each
Previous Run	: 42716		
Written By	:		
Checked & Approved By	: <u>JND 08.10.03</u>		
Comment	: Est. A 02.08.23 New issue KJ		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
			
Comment: Qty.: 5.2500 f(s)/Unit Total: 105.0000 f(s) 304 SQ Tube.75x.75x.065W (M304TS0750W065) Material: 304/316 SS tube 0.065" wall Batch <u>1M/09731</u> <u>SAD</u> <u>08-11-26</u>			
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
			
Comment: LANDING GEAR RESOURCE 1 Cut 3/4" x 3/4" square tubing 60.00" long. <u>SAD</u> <u>08-11-26</u> (20)			
3.0	BENDING	BENDING MACHINE - SKIDTUBES	
			
Comment: BENDING MACHINE <u>350 BASRE</u> Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program <u>350 BASRE</u> , and folio FT004. <u>FT 08-12-01</u> (20)			
4.0	QC6	DIMENSIONAL CHECK	
			
Comment: DIMENSIONAL CHECK Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302) <u>Sos12/03</u> (20)			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>WA</u> <u>SAD</u> <u>08-12-03</u> (20)			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3166-1 PAR #: N/A Fault Category: Skid tube Pro Eng Log NCR: Yes No DQA: ll Date: 08.12.04
 Resolution: _____ Disposition: _____ QA: N/C Closed: ll Date: 08/12/05

NCR: <u>43165</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-12-01</u>	<u>3.0</u>	<u>2 Basket Rib over bent by 1 1/2". used wrong program identified on wo. (350 BASB) the right program to use is 350 BASB</u>	<u>ll</u>	<u>Review all stored programs in the bander, and archive any unnecessary programs.</u> <u>Scrap the 2 ribs & replace 2 x m 109731</u>	<u>ll</u> <u>08-12-01</u>	<u>S</u> <u>08/12/03</u>	<u>ll</u>	<u>08.12.01</u>
		<u>R.C: 2 different programs in the machine, for the same part.</u>	<u>ll</u>	<u>review the correct bend program: update the Estimate to state the good program.</u> <u>ESTIMATE: 10402</u>	<u>ll</u> <u>08.12.05</u>		<u>ll</u>	<u>06-12-01</u>

NOTE: Date & initial all entries

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Drawing Name: BASKET RIB

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/04 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mk 08-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

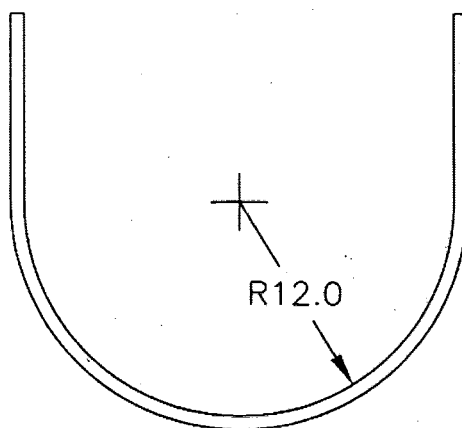
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A	02.07.10	NEW ISSUE	
A1	04.04.08	38+/-1 WAS 36.0	

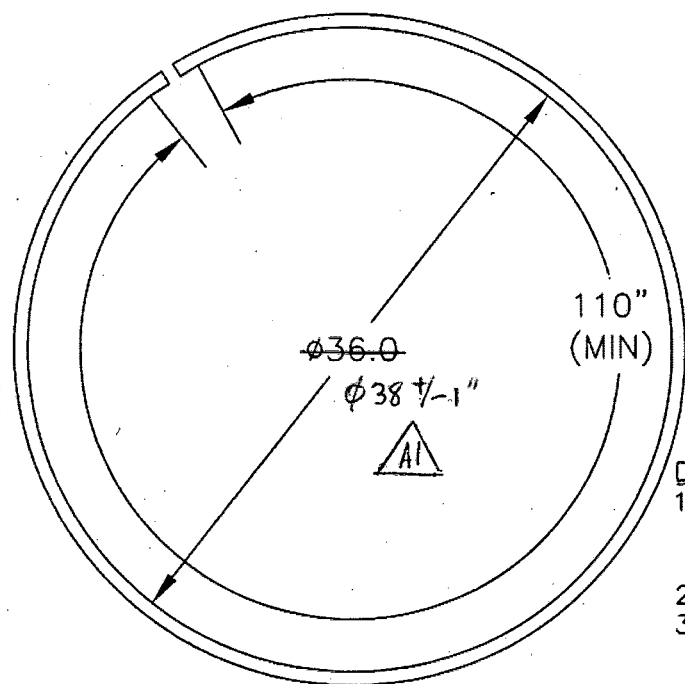
RELEASED
02.08.06



10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43165

D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries